



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4125-1

Job Sheet 180684



Part No: D4125-1

Job Qty: 4 ea

Part Name: Fwd Sediment Bowl



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/12/18

Job Tracking No:

Due Date: 7/31/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E SHEET 1 IPP Rev:A 10.07.21 new issue DD verf:EC IPP Rev:B 11/12/05 as per dwg. rev.B JFS
verf:DD IPP REV:C 15.03.04 remove alodine and add holes DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		7/31/18	0.00	0.00	Start Up Machining-2		
100	Bandsaw	4 pcs		7/31/18	0.00	0.01	Bandsaw1		
105	CNC Vertical Machining	4 pcs		7/31/18	0.96	16.00	HAAS 5 Axis		
110	QC	4 pcs		7/31/18	0.00	16.00	QC2 Machining-2		
120	QC	4 pcs		7/31/18	0.00	0.00	QC8 Machining-2		
150	Packaging	4 pcs		7/31/18	0.00	0.00	Packaging3-2		
160	QC21-SA	4 Ea		7/31/18	0.00	0.00	QC21		

Part Op 100 - 1-Cut Blank at 13.375"

Descriptions: 105 - Machined as per folio FB078 Rev: _____ Dwg: _____

120 -

150 - LOCATION: WA003

DAS
21
9-89

OCT 29 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B2.000X08.000	6061-T6 Bar 2.00' X 8.00" (Cut In 4Ft Section)	4.4600 ft (1.115 ea)	90-Start up Operation	S120 681 S120 682

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B2.000X08.000	4	13	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fwd Sediment Bowl	0.140Inches ± 0.030	0.170 0.110		.140
2	Fwd Sediment Bowl	0.260Inches ± 0.030	0.290 0.230		.260
3	Fwd Sediment Bowl	0.200Inches ± 0.030	0.230 0.170		.200
4	Fwd Sediment Bowl	0.200Inches ± 0.030	0.230 0.170		.200
5	Fwd Sediment Bowl	6.230Inches ± 0.030	6.260 6.200		6.232

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐							
Misidentified ☐	Past Due ☐								

6	Fwd Sediment Bowl	3.560Inches ± 0.030	3.590 3.530	3.560
7	Fwd Sediment Bowl	2.610Inches ± 0.030	2.640 2.580	2.610
8	Fwd Sediment Bowl	0.250Inches ± 0.030	0.280 0.220	.250
9	Fwd Sediment Bowl	0.250Inches ± 0.030	0.280 0.220	.250
10	Fwd Sediment Bowl	11.870Inches ± 0.030	11.900 11.840	11.870
11	Fwd Sediment Bowl	0.310Inches ± 0.030	0.340 0.280	.311
12	Fwd Sediment Bowl	6.010Inches ± 0.030	6.040 5.980	6.012
13	Fwd Sediment Bowl	11.980Inches ± 0.030	12.010 11.950	11.980
14	Fwd Sediment Bowl	0.060Inches ± 0.030	0.090 0.030	.063
15	Fwd Sediment Bowl	0.430Inches ± 0.030	0.460 0.400	.428
16	Fwd Sediment Bowl	2.180Inches ± 0.030	2.210 2.150	2.176
17	Fwd Sediment Bowl	7.156Inches ± 0.005	7.161 7.151	7.158
18	Fwd Sediment Bowl	0.257Inches + 0.006 - 0.001	0.263 0.256	.257
19	Fwd Sediment Bowl	1.370Inches ± 0.030	1.400 1.340	1.400
20	Fwd Sediment Bowl	0.348Inches + 0.006 - 0.001	0.354 0.347	.348
21	Fwd Sediment Bowl	2.990Inches ± 0.030	3.020 2.960	2.987
22	Fwd Sediment Bowl	0.300Inches ± 0.030	0.330 0.270	.298

Plex 7/12/18 7:27 AM Dart.lajeunesse.marie



Container No: S120684



Part: D4125-1

Job No: 180684

Serial No/Batch: S120684

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/23/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																					
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